

Work Order ID 86316

Wednesday, June 27, 2012 9:28:42 AM

86316

Today

Page 1

Item ID: D4170-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bushing

Stop

NS2

Start Date: 6/27/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/27/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

MF

Date:

12-06-27

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4170

B

100

0.00

100

Hardinge

Hardinge CNC LATHE SMALL

0.00

12-06-27

4

Hardinge CNC Lathe Small

Memo

Machine as per Folio FA989

FOLIO REV:

DWG REV:

DEBURR

Manual

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

12-06-27

4

Quality Control

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Page 2

Item ID: D4170-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bushing

Start Date: 6/27/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/27/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

*St/D.A 12/06/27**4**✓*

125

0.00

125

Skidtubes

Memo

0.00

Skidtubes

1- clean crossbolt spacer with ultra bright aluminum cleaner before storing.

CF 40 12-6-27

130

Identify as per dwg & Stock Location: *ST 104* 0.00***130***

Packaging

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL

*ex. SP**12-6-27*

Picklist Print

Wednesday, June 27, 2012 9:28:41 AM

Page 1

Work Order ID: 86316

Parent Item: D4170-3

Parent Item Name: Bushing

Start Date: 6/27/2012

Required Date: 6/27/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-10-28 JLM VERIFIED BY:DD IPP Rev:A 10.11.02 as per
revB DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.500 6061-T6 Round Bar .500"		Purchased	No			100	f	104.9680	0.275	1.1578947			

Location

Loc Qty

Loc Code

MAT012

104.968

114488

1.997

117379

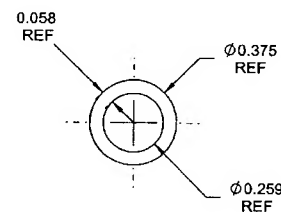
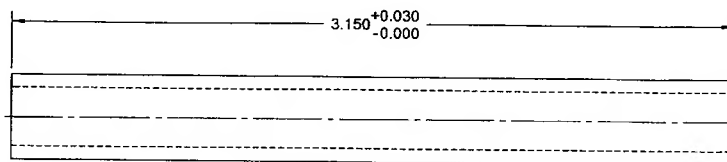
9.288

118043

93.683

1.12

12-06-27



86316

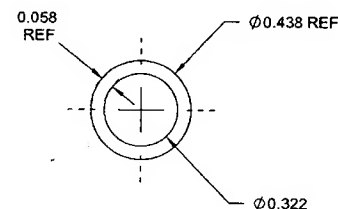
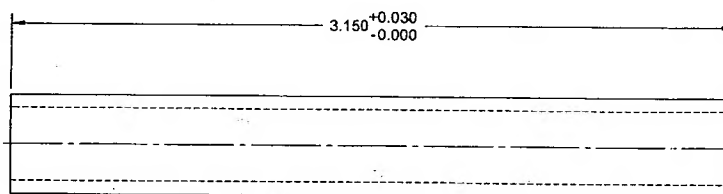
D4170-1 SPACER

RELEASED
2010-11-01

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, Ø 3/8 OD X 0.058 WALL
PER WW-T-700/6, AMS 4080, AMS 4082, QQ-A-200/8, OR QQ-A-225/8
REF DART SPEC. M6061T6T0.375W.058
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01lbs

B	ADD -3 (SHEET 2)	CP	10.10.25
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	<i>g</i>	DRAWING NO.	REV. B
CHECKED	<i>g</i>	D4170	SHEET 1 OF 2
MFG. APPR.	<i>g</i>	TITLE	SCALE
APPROVED	<i>g</i>	SPACER	NTS
DE APPR.	<i>g</i>	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.	
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Handwritten: 186316

△ D4170-3 SPACER

RELEASED
2010-11-01

NOTES:

- 1) MATERIAL: 6061-T6 ROUND BAR, Ø7/16 OD
PER QQ-A-225/8, QQ-A-200/8, ASTM B211, OR ASTM B221
REF DART SPEC. M6061T6R0.438
- OR
6061-T6 OR 6061-T62 TUBING, Ø7/16 OD X 0.058 WALL
PER WW-T-700/6, AMS 4080, AMS 4082, QQ-A-200/8, OR QQ-A-225/8
REF DART SPEC. M6061T6T0.438W.058
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01lbs

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	<i>JP</i>	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D4170	REV. B
MFG. APPR.		SHEET 2 OF 2	
APPROVED		TITLE	SCALE
DE APPR.		SPACER	NTS
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